

Work Order ID 54572

December 14, 2009 10:43:09 AM



Page 1

Item ID: D3136-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 14/12/2009 Start Qty: 8.00



Cust ID:

Required Date: 24/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

01-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

E
E

0.00

FLOW CNC Waterjet

HB 9-12-15

(9)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-12-15

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 506/2/15

(x9)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA002 Dwg
Rev. E □ Folio Rev. B □ 2- Engrave Part # and
Batch #, and affix labels □ (D3136-3)

Sh 09/12/17
(X)

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Sh 09/12/17
(X)

150

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2) S 09/12/18

(X)

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

DL 02/12/17

(X9)

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

27 Serials

(XS)

180

0.00



Identify as per dwg & Stock Location: 216

Packaging

Memo

0.00

Packaging

PC 09/12/23 (9)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/01/07

C209112123

W/O:		WORK ORDER CHANGES					
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Picklist Print

December 14, 2009 10:43:14 AM

Page 1

Work Order ID: 54572

Parent Item: D3136-043

Parent Item Name: Window Assembly

Start Date: 14/12/2009

Required Date: 24/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3108-9		Manufactured	No			100	Each	780.0000	16.0000			

Decal

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 780

34554 292

46546 488

MACRLICS.125

Purchased

No

170 sf

229.6270 31.2000



1/8" Polycast II Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 229.627

110115 4

110633 17.2295

111711 67.7447

112888 0.7828

113204 139.87

18 Dh 09/12/17

50

R 9-12-15

69

113204

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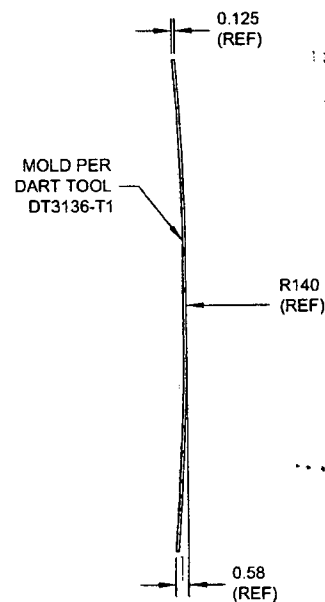
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



NOTE: Date & initial all entries



PL 09-12-14

RELEASE
07-09-22

NOTES:

- | | | | |
|------------|---|---|--------------|
| E | REMOVE TRIM NOTE | DC | 07.09.10 |
| D | UPDATED MATERIAL NOTES | RJ | 05.12.01 |
| C | ADDED FORMING & ENGRAVING SPEC | KF | 04.05.05 |
| B | ADDED D3136-3 AND D3136-043 | RJ | 04.01.21 |
| A | NEW ISSUE | DS | 02.04.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN |  | DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA | |
| DRAWN |  | DRAWING NO. | REV. 1 |
| CHECKED |  | D3136 | SHEET 1 OF 1 |
| MFG. APPR. |  | TITLE | SCALE |
| APPROVED |  | WINDOW ASSEMBLY | 1 |
| DE APPR. |  | COPYRIGHT © 2002 BY DART AEROSPACE LTD
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| DATE | 07.09.10 | | |

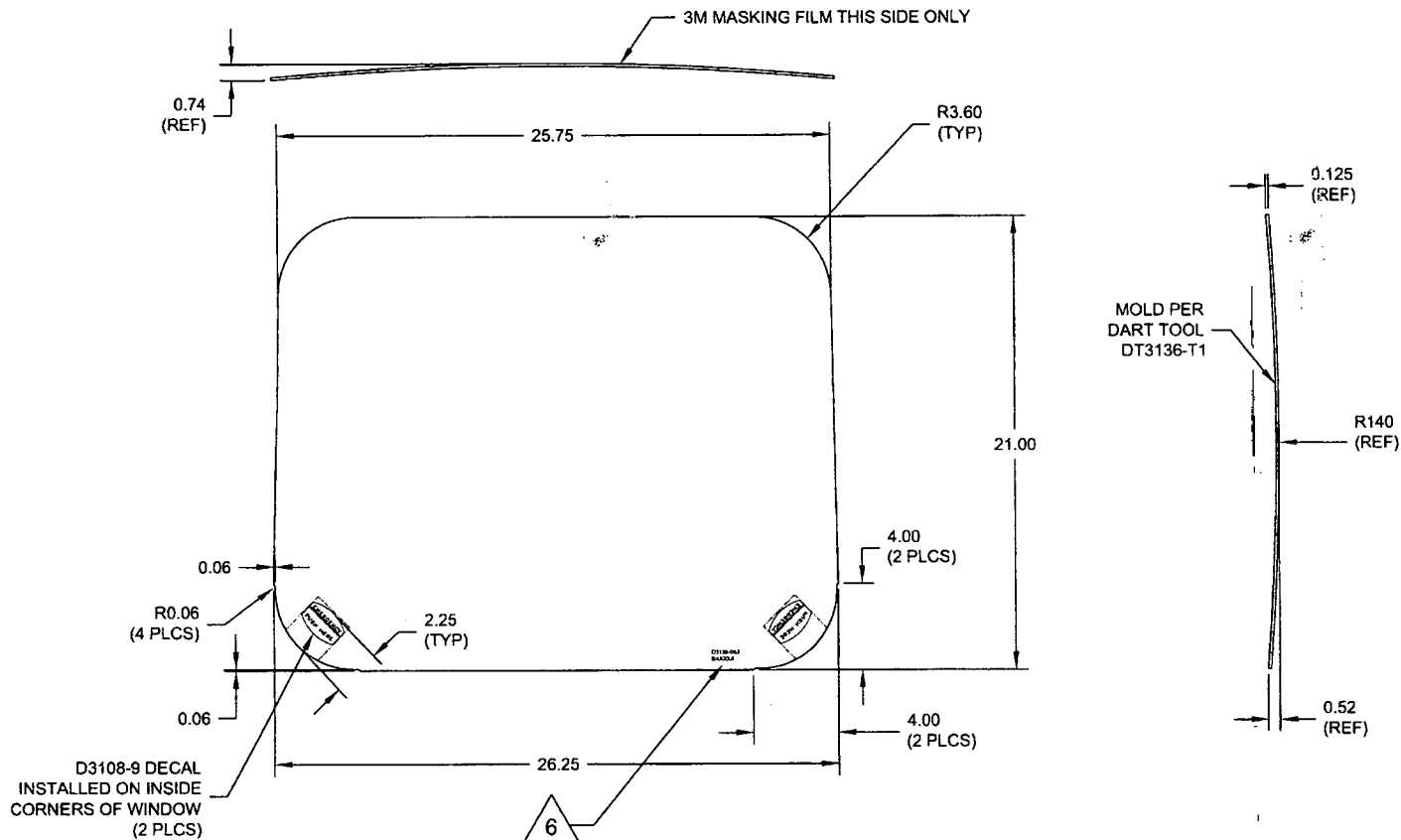
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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22

DESIGN	4	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JC	DRAWING NO.	REV. E
MFG. APPR.	JC	D3136	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WINDOW ASSEMBLY	1:6
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